

CLAIM AMENDMENTS:

1. (Currently Amended) Apparatus for controlling the flow of molten metal into a device for the manufacturing of articles of cast metal, the apparatus comprising:
a pressurizing conduit having an entrance, an exit, and a working area, said pressurizing conduit being resistant to the heat and corrosive effect of the molten metal being controlled,

at least one pair of electrodes at the walls of said pressurizing conduit, said electrodes being positioned to provide between them a flow of direct current substantially perpendicularly through and across said flow of molten metal;

first and second assemblies of neo-magnets comprising a rare-earth element, said assemblies positioned on opposite sides of said conduit for providing magnetic flux extending through said working area in a direction generally perpendicular to flow of molten metal in said working area and said flow of direct current;

said first and second assemblies of neo-magnets including first and second pole pieces of magnetically soft ferromagnetic material respectively positioned on opposite sides of said conduit.

~~at least one permanent neo-magnet comprising a rare-earth element,
said neo-magnet being positioned in a circuit of magnetically soft ferromagnetic material which applies north-south unidirectional magnetic flux substantially perpendicular to said working area of said pressurizing conduit, and
said magnetic flux being in a direction substantially perpendicular to both said flow of molten metal and said flow of direct current.~~

2.-46. (Cancelled)

47. (Previously Presented) Apparatus for controlling flow of molten metal comprising:

a conduit formed of non-magnetic material having a passage suitable for controlling flow of molten metal in said passage;

first and second assemblies of neo-magnets positioned on opposite sides of said conduit for providing an intense magnetic field B extending through said passage in a direction generally perpendicular to flow M of molten metal in said passage;

first and second electrodes mounted on opposite sides of said conduit;

said electrodes being positioned for electrically conductive communication with molten metal within said passage,

said first and second electrodes being suitable for connection in an electrical circuit with an electrical source of direct current for providing said first and second electrodes respectively with positive and negative voltage in said electrical circuit for causing electrical direct current I to flow through molten metal in said passage in a direction generally perpendicular to said intense magnetic field B and also generally perpendicular to flow M of molten metal;

said first and second assemblies of neo-magnets including first and second pole pieces of magnetically soft ferromagnetic material respectively positioned on opposite sides of said conduit;

said first pole piece having a pole face oriented generally perpendicular to said magnetic field B and being positioned near and facing toward a first side of said conduit;

said first assembly including a first plurality of neo-magnets positioned with their North poles adjacent to said first pole piece for providing North magnetic polarization of said pole face of said first pole piece;

said second pole piece having a pole face oriented generally perpendicular to said magnetic field B and being positioned near and facing toward a second side of said conduit opposite to said first side thereof;

said second assembly including a second plurality of neo-magnets positioned with their South poles adjacent to said second pole piece for providing South magnetic polarization of said pole face of said second pole piece;

a first enclosure of magnetically soft ferromagnetic material positioned around said first assembly; and

a second enclosure of magnetically soft ferromagnetic material positioned around said second assembly.

48. (Previously Presented) Apparatus for controlling flow of molten metal comprising:

a conduit formed of non-magnetic material having a passage suitable for controlling flow of molten metal in said passage;

first and second assemblies of neo-magnets positioned on opposite sides of said conduit for providing an intense magnetic field B extending through said passage in a direction generally perpendicular to flow M of molten metal in said passage;

first and second electrodes mounted on opposite sides of said conduit;

said electrodes being positioned for electrically conductive communication with molten metal within said passage;

said first and second electrodes being suitable for connection in an electrical circuit with an electrical source of direct current for providing said first and second electrodes respectively with positive and negative voltage in said electrical circuit for causing electrical direct current I to flow through molten metal in said passage in a direction generally perpendicular to said intense magnetic field B and also generally perpendicular to flow M of molten metal;

said first and second assemblies of neo-magnets including first and second pole pieces of magnetically soft ferromagnetic material respectively positioned on opposite sides of said conduit;

said first pole piece being elongated and being oriented in a direction generally parallel with said direction of flow of direct current I ;

said elongated first pole piece also being oriented in a direction generally transverse to said direction of flow M of molten metal;

said elongated first pole piece having an elongated pole face positioned near and facing toward a first side of said conduit and being oriented generally parallel with said direction of flow of direct current I and also being oriented generally transverse to said direction of flow M of molten metal;

said first assembly-including a first plurality of neo-magnets positioned with their North poles adjacent to said elongated first pole piece for providing North magnetic polarization of said elongated pole face of said elongated first pole piece;

said second pole piece being elongated and being oriented in a direction generally parallel with said direction of flow of direct current I ;

said elongated second pole piece also being oriented in a direction generally transverse to said direction of flow M of molten metal;

said elongated second pole piece having an elongated pole face positioned near and facing toward a second side of said conduit opposite to said first side thereof and being oriented generally parallel with said direction of flow of direct current I and also being oriented generally transverse to said direction of flow M of molten metal; and

said second assembly including a second plurality of neo-magnets positioned with their South poles adjacent to said elongated second pole piece for providing South magnetic polarization of said elongated pole face of said elongated second pole piece.

49. (Currently Amended) Apparatus for controlling flow of molten metal claimed in Claim [[62]] 48,

wherein:

said first assembly includes elongated neo-magnets extending parallel with said elongated first pole piece; and

said second assembly includes elongated neo-magnets extending parallel with said elongated second pole piece.

50. (Currently Amended) Apparatus for controlling flow of molten metal claimed in claim [[62]] 48, wherein:

said first assembly also includes neo-magnets having North poles adjacent to ends of said elongated first pole piece; and

said second assembly also includes neo-magnets having South poles adjacent to ends of said elongated second pole piece.

51. (Previously Presented) Apparatus for controlling flow of molten metal comprising:

a conduit formed of non-magnetic material having a passage suitable for controlling flow of molten metal in said passage;

first and second assemblies of neo-magnets positioned on opposite sides of said conduit for providing an intense magnetic field B extending-through said passage in a direction generally perpendicular to flow M of molten metal in said passage;

first and second electrodes mounted on opposite sides of said conduit;
said electrodes being positioned for electrically conductive communication with molten metal within said passage;
said first and second electrodes being suitable for connection in an electrical circuit with an electrical source of direct current for providing said first and second electrodes respectively with positive and negative voltage in said electrical circuit for causing electrical direct current I to flow through molten metal in said passage in a direction generally perpendicular to said intense magnetic field B and also generally perpendicular to flow H of molten metal;
first and second neo-magnet assemblies each including eight neo-magnets;
said first and second assemblies being respectively positioned on opposite sides of said conduit;
said first neo-magnet assembly including an inner tier of four neo-magnets having their North poles positioned near and facing toward a first side of said conduit;
said first neo-magnet assembly including an outer tier of four neo-magnets having their North poles positioned adjacent to respective South poles of the four neo-magnets in said inner tier;
said second neo-magnet assembly including an inner tier of four neo-magnets having their South poles positioned near and facing toward a second side of said conduit opposite to said first side thereof;
said second neo-magnet assembly including an outer tier of four neo-magnets having their South poles positioned adjacent to respective North poles of the four neo-magnets in said inner tier;
non-magnetic retainers positioned around said first and second neo-magnet assemblies for holding together said first and second neo-magnet assemblies; and
a frame of magnetically soft ferromagnetic material encircling said first and second neo-magnet assemblies and also encircling said conduit.

52. (Currently Amended) Apparatus for controlling flow of molten metal claimed in claim [[65]] 51, wherein:

said eight neo-magnets in each of said first and second neo-magnet assemblies are cubical in configuration; and

said first and second neo-magnet assemblies are cubical in overall configuration.

53. (Previously Presented) Apparatus for controlling flow of molten metal comprising:

a conduit formed of non-magnetic material having a passage suitable for controlling flow of molten metal in said passage; first and second assemblies of neo-magnets positioned on opposite sides of said conduit for providing an intense magnetic field B extending through said passage in a direction generally perpendicular to flow M of molten metal in said passage;

first and second electrodes mounted on opposite sides of said conduit;

said electrodes being positioned for electrically conductive communication with molten metal within said passage;

said first and second electrodes being suitable for connection in an electrical circuit with an electrical source of direct current for providing said first and second electrodes respectively with positive and negative voltage in said electrical circuit for causing electrical direct current I to flow through molten metal in said passage in a direction generally perpendicular to said intense magnetic field B and also generally perpendicular to flow M of molten metal;

said first and second assemblies of neo-magnets including first and second pole pieces of magnetically soft ferromagnetic material respectively positioned on opposite sides of said conduit;

said first pole piece having a pole face positioned near and facing toward a first side of said conduit;

said second pole piece having a pole face positioned near and facing toward a second side of said conduit opposite to said first side thereof;

said first pole piece having a plurality of surfaces extending from the pole face thereof;

said surfaces of the first pole piece being oriented generally perpendicular to said pole face of said first pole piece;

said first assembly including a plurality of neo-magnets having North poles adjacent to respective surfaces of the first pole piece for providing North magnetic polarity for said pole face of the first pole piece;

said second pole piece having a plurality of surfaces extending from the pole face thereof;

said surfaces of the second pole piece being oriented generally perpendicular to said pole face of the second pole piece; and

said second assembly including a plurality of neo-magnets having South poles adjacent to respective surfaces of the second pole piece for providing South magnetic polarity for said pole face of the second pole piece.

54. (Currently Amended) Apparatus for controlling flow of molten metal claimed in Claim ~~[[67]]~~ 53,

wherein:

said first and second pole pieces are equilateral triangular parallelepipeds; and
said first and second assemblies each include three neo-magnets.

55. (Currently Amended) Apparatus for controlling flow of molten metal claimed in Claim ~~[[68]]~~ 54, wherein:

said first and second pole pieces have outer ends configured as equilateral triangles;

said first assembly includes a neo-magnet having an equilateral triangular configuration having a North pole positioned adjacent to the outer end of the first pole piece; and

said second assembly includes a neo-magnet having an equilateral triangular configuration having a South pole positioned adjacent to the outer end of the second pole piece.

56. (Currently Amended) Apparatus for controlling flow of molten metal claimed in Claim ~~[[67]]~~ 53,

wherein:

said first and second pole pieces are rectangular parallelepipeds; and

said first and second assemblies each include four neo-magnets.

57. (Currently Amended) Apparatus for controlling flow of molten metal claimed in Claim ~~[[67]]~~ 53, wherein:

said first and second pole pieces are square parallelepipeds; and
said first and second assemblies each include four neo-magnets.

58. (Currently Amended) Apparatus for controlling flow of molten metal claimed in Claim ~~[[71]]~~ 57, wherein:

said first and second pole pieces have square outer ends;
said first assembly includes a neo-magnet having a square North pole adjacent to the square outer end of the first pole piece; and
said second assembly includes a neo-magnet having a square South pole adjacent to the square outer end of the second pole piece.

59. (Currently Amended) Apparatus for controlling flow of molten metal claimed in Claim ~~[[67]]~~ 53, wherein:

said first and second pole pieces are hexagonal in cross section; and
said first and second assemblies each include six neo-magnets.

60. (Currently Amended) Apparatus for controlling flow of molten metal claimed in Claim ~~[[73]]~~ 59, wherein:

said first and second pole pieces have hexagonal outer ends;
said first assembly includes a neo-magnet having a hexagonal North pole adjacent to the hexagonal outer end of the first pole piece; and
said second assembly includes a neo-magnet having a hexagonal South pole adjacent to the hexagonal outer end of the second pole piece.

61. (Previously Presented) Apparatus for controlling flow of molten metal comprising:

a conduit formed of non-magnetic material having a passage suitable for controlling flow of molten metal in said passage;

first and second neo-magnets positioned on opposite sides of said conduit for providing an intense magnetic field B extending through said passage in a direction generally perpendicular to flow M of molten metal in said passage;

first and second electrodes mounted on opposite sides of said conduit;

said electrodes being positioned for electrically conductive communication with molten metal within said passage;

said first and second electrodes being suitable for connection in an electrical circuit with an electrical source of direct current for providing said first and second electrodes respectively with positive and negative voltage in said electrical circuit for causing electrical direct current I to flow through molten metal in said passage in a direction generally perpendicular to said intense magnetic field B and also generally perpendicular to flow M of molten metal;

said first and second assemblies of neo-magnets including first and second pole pieces of magnetically soft ferromagnetic material respectively positioned on opposite sides of said conduit;

said first and second pole pieces being circular cylindrical; and

said first and second neo-magnets being annular rings respectively encircling the first and second circular cylindrical pole pieces;

said first neo-magnet being magnetized in a direction through its radial thickness and having an inner North pole adjacent to the first circular cylindrical pole piece; and said second neo-magnet being magnetized in a direction through its radial thickness and having an inner South pole adjacent to the second circular cylindrical pole piece.

62. (Currently Amended) Apparatus for controlling flow of molten metal claimed in Claim ~~[[75]]~~ 61, wherein:

said first and second pole pieces have circular outer ends;

a circular neo-magnet has a North pole adjacent to the circular outer end of the first pole piece; and

another circular neo-magnet has a South pole adjacent to the circular outer end of the second pole piece.

63. (Previously Presented) A method for controlling flow of molten metal comprising steps of:

- providing a pressurizing conduit formed of non-magnetic material;
- providing said pressurizing conduit having a generally constant height and a generally constant width throughout the working area of said pressurizing conduit; said width being greater than said height;
- positioning at least one neo-magnet above said working area;
- positioning at least one neo-magnet below said working area;
- said neo-magnet positioned above said working area having its north polarity pole face oriented in a magnetic circuit B for directing its magnetic flux through said working area;

- said neo-magnet positioned below said working area having its south polarity pole face oriented in said magnetic circuit B for directing its magnetic flux through said working area in additive relationship relative to the magnetic flux of said neo-magnet positioned above said working area of said pressurizing conduit;

- positioning a DC electrode having positive electrical potential on one side of said working area of said pressurizing conduit; positioning a DC electrode having negative electrical potential on the opposite side of said working area of said pressurizing conduit from said DC electrode having positive electrical potential; and said electrodes being positioned for electrical conductive communication with molten metal M within said working area of the pressurizing conduit.

64. (Currently Amended) Apparatus for controlling flow of molten metal claimed in claim [[77]] 62, wherein:

- said electrodes have a greater length in electrical conductive communication with molten metal M in the direction of flow of said molten metal M than their height in electrical conductive communication with molten metal M in the direction of magnetic flux passing through said molten metal M.

65. (Currently Amended) A method for controlling flow of molten metal claimed in claim 63, further comprising:

mounting said electrodes in electrically non-conductive electrode holders seated within opposite walls of the working area of the pressurizing conduit with portions of the electrodes being exposed to electrically conductive communication to molten metal in the working area of the pressurizing conduit.

66. (Currently Amended) A method for controlling flow of molten metal claimed in Claim [[79]] 65, wherein:

said electrode holders are seated within exterior portions of the wall of the pressurizing conduit; and

each of said electrodes has a portion which protrudes inwardly from its electrode holder into electrically conductive communication with molten metal M within the working area of the pressurizing conduit.

67. (Previously Presented) A method for controlling flow of molten metal comprising steps of:

providing a pair of elongated neo-magnets of equal length each having elongated magnetically polarized pole faces extending for the length of the neo-magnet;

positioning said elongated neo-magnets in vertically spaced parallel relationship with one of said elongated neo-magnets being positioned above a working area of a pressurizing conduit and the other of said elongated neo-magnets being positioned below said working area of the pressurizing conduit;

orienting the magnetically polarized pole faces of the elongated neo-magnets for directing their magnetic flux in magnetically additive relation in a magnetic flux circuit B passing through the working area of the pressurizing conduit; and

positioning said elongated neo-magnets with their length extending generally perpendicular to flow of molten metal within the working area of the pressurizing conduit, thereby providing a molten metal pump having a pressurizing passage with a flow width more than ten times greater than its height.

68. (Currently Amended) A method for controlling flow of molten metal comprising steps of:

providing a pressurizing conduit formed of non-magnetic material;

providing said pressurizing conduit having a generally constant height and a generally constant width throughout the working area of said pressurizing conduit;

said width being greater than said height;

positioning at least one neo-magnet above said working area;

positioning at least one neo-magnet below said working area;

said neo-magnet positioned above said working area having its north polarity pole face oriented in a magnetic circuit B for directing its magnetic flux through said working area;

said neo-magnet positioned below said working area having its south polarity pole face oriented in said magnetic circuit B for directing its magnetic flux through said working area in additive relationship relative to the magnetic flux of said neo-magnet positioned above said working area of said pressurizing conduit;

positioning a DC electrode having positive electrical potential on one side of said working area of said pressurizing conduit;

positioning a DC electrode having negative electrical potential on the opposite side of said working area of said pressurizing conduit from said DC electrode having positive electrical potential;

said electrodes being positioned for electrical conductive communication with molten metal M within said working area of the pressurizing conduit;

positioning four flow-sensing electrodes in electrically conductive communication with molten metal M within said working area of the pressurizing conduit;

two of said flow-sensing electrodes being positioned upstream relative to the flow of molten metal M within said working area;

two of said flow-sensing electrodes being positioned downstream relative to the flow of molten metal M within said working area;

said flow-sensing electrodes being symmetrically positioned upstream and downstream relative to the flow of molten metal M in said working area and also being symmetrically positioned left and right relative to the flow of molten metal M in said working area; and

combining and averaging electrical outputs from said sensing electrodes for ~~cancelling~~ canceled undesired e.m.f.s to not distort the generated and combined

control e.m.f. to be fed into a meter or control for D.C. current I being fed through molten metal M within said working area of the pressurizing conduit.

69. (Cancelled)

70. (Cancelled)